

Work Order ID 71568

Wednesday, July 06, 2011 1:19:36 PM



Page 1

Item ID: D3560-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Arm Weldment

Start Date: 7/6/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/22/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: CL Date: 11/07/06 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3560

Rev D

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks 16.750" long

aml 11/07/08

4

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Mill as per Folio FA693 Rev: AA & Dwg D3560 Rev: D
2-C'sink 0.196" hole on manual mill as per dwg D3560
3-Deburr per dwg D3560

SL 11-07-26

(4)

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

SL 11-07-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		RE 11.7.27		4			
140 Large Fab Large Fab	Large Fab Memo 1-Weld assembly as per dwg D3560 STEP: 1- clean material (buff bracket and bottom of arm with blue pad) 2- set up bracket and arm on jig 3- preheat bracket and arm with torch 4- clean before welding with brush 5- set up machine to 135 amps 6- weld across bottom and top ends 7- reheat with torch (65 deg C) 8- on one side weld from bottom to top half way 9- same for other side (half way) 10- from half way point weld the rest of the first side (ease off pedal near end) 11- same for remaining side (ease off pedal near end)	0.00 0.00		11.08.04		4	0		

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Page 3

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Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Suloslos

24

04/

160

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

4 Ø BE 11/08/04

170

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

4x Ø M-11/08/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 71568

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Page 4

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Start Date: 7/6/2011 Start Qty: 4.00

Cust Item ID:

Required Date: 7/22/2011 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

4 6 10 11/08/08

190

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1-Press bushing in D3560 arm per dwg D3562

SP/08/10

200

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

5/10/10

44

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

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Page 5

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Cust Item ID:

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Customer:

Reference:

Run Start

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

210

Identify as per dwg & Stock Location: WA

0.00



Packaging

Memo

0.00

Packaging

*** STOCK IN STEP CELL***

MAE 11-08-10

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 11/08/11

*11-08-11
(4)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Wednesday, July 06, 2011 1:19:33 PM

Page 1

Work Order ID: 71568

Parent Item: D3560-041

Parent Item Name: Arm Weldment



Start Date: 7/6/2011

Required Date: 7/22/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07.05.24 EC
IPP rev B ECN 987 07.10.09 EC verified by: DD
IPP Rev:C ECN1048 07-12-18 DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2808 Bushing		Manufactured	No			100	Each	25.0000	1	4			(P)
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>GA</div> <div>2</div> <div></div> </div>													
<div> <div>32896</div> <div>2</div> <div></div> </div>													
<div> <div>ST023</div> <div>23</div> <div></div> </div>													
<div> <div>69609</div> <div>3</div> <div></div> </div>													
<div> <div>69892</div> <div>20</div> <div></div> </div>													
M6061T6B0.500X05.00 0		Purchased	No			140	f	46.9350	1.395	5.873684			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>MAT004</div> <div>46.935</div> <div></div> </div>													
<div> <div>112154</div> <div>6.935</div> <div></div> </div>													
<div> <div>→ 117933</div> <div>40</div> <div></div> </div>													
D3592-1		Manufactured	No			190	Each	49.0000	1	4			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>WA002</div> <div>49</div> <div></div> </div>													
<div> <div>47015</div> <div>2</div> <div></div> </div>													
<div> <div>48517</div> <div>47</div> <div></div> </div>													

371359 71879

35

5.9 and 11/07/08
11.08.04

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	71568
Description: Arm		Part Number:	D3560-1
Inspection Dwg: D3560 Rev: D		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

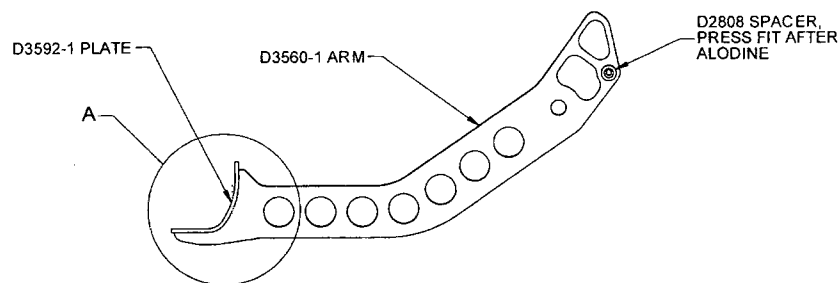
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.507	+0.000/-0.001	506	✓		MT 9526E	
Ø0.196	+0.005/-0.001	197	✓		vern. JL-3	
Ø1.000	+0.010/-0.001	1.002	✓		"	
0.500	+/-0.010	.485		✓	"	stock mat'l
0.250	+/-0.010	.250	✓		"	
0.275	+/-0.010	.274	✓		"	
0.188	+/-0.010	.187	✓		"	
2.000	+/-0.010	1.999	✓		"	
1.700	+/-0.010	1.699	✓		"	
Ø0.385 x 100°	+/-0.010 x 0.5°	380 x 100°	✓			
0.250 Deep	+/-0.010	.251	✓		"	

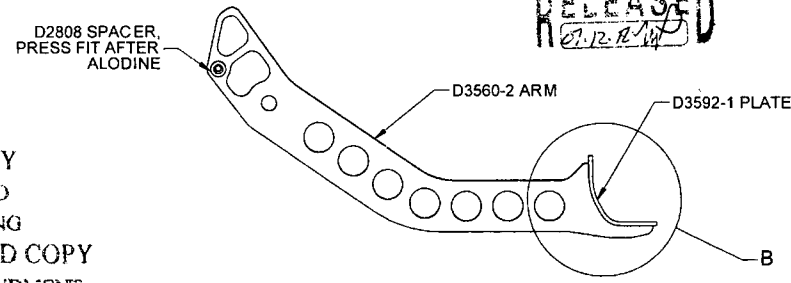
Measured by:	JL	Audited by:	RQ	Prototype Approval:	N/A
Date:	11-07-06	Date:	11.7.27	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.01.17	New Issue P/O D3560-041	KJ/JLM	
B	07.06.13	Dimensions updated per Dwg Rev B	KJ/JLM	
C	08.07.24	Dwg Rev updated	KJ/DD	

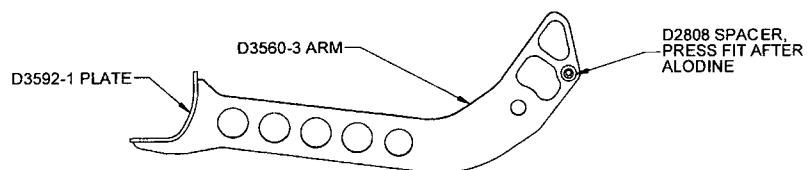
RELEASED
27-12-14



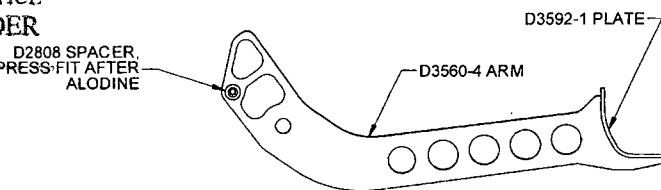
D3560-041 ARM WELDMENT



D3560-042 ARM WELDMENT

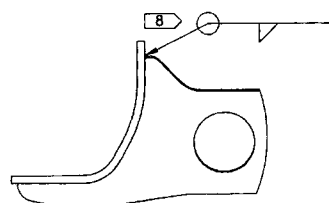


D3560-043 ARM WELDMENT



D3560-044 ARM WELDMENT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 71568
CL 11/07/04



**DETAIL A
SCALE 1:2**

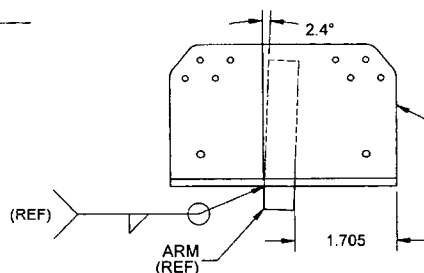
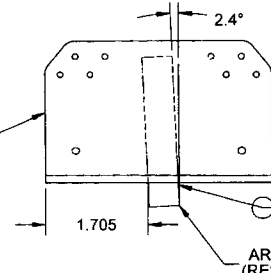
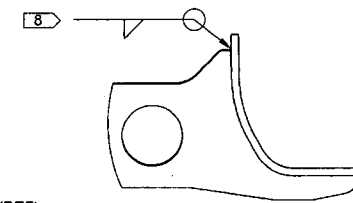


PLATE
(REF)

ARM
(REF)



ARM
(REF)



**DETAIL B
SCALE 1:2**

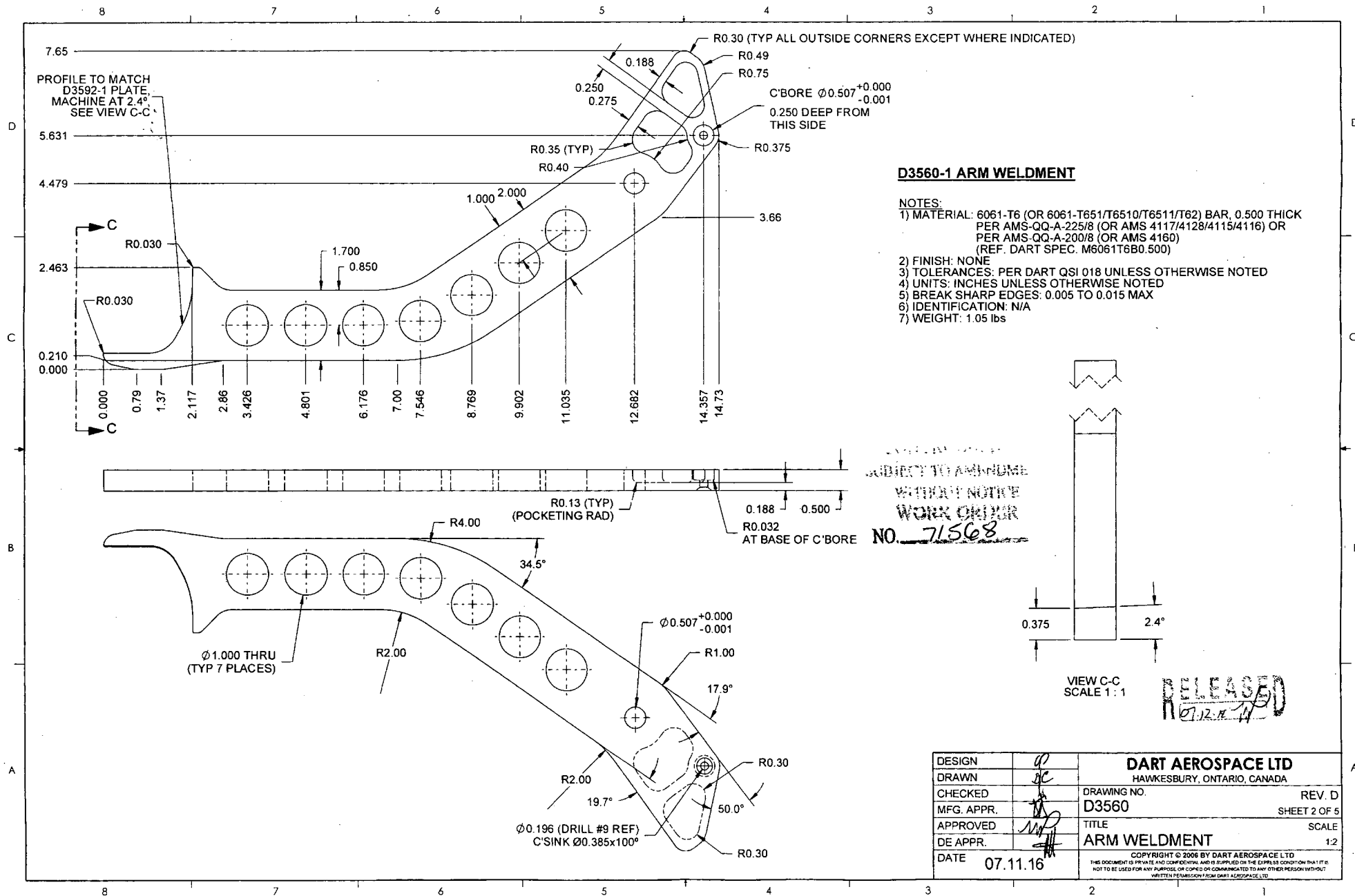
PARTS LIST

QTY -041	QTY -042	QTY -043	QTY -044	P/N	DESCRIPTION
X				D3560-041	ARM WELDMENT
	X			D3560-042	ARM WELDMENT
		X		D3560-043	ARM WELDMENT
			X	D3560-044	ARM WELDMENT
1	1	1	1	D2808	SPACER
1				D3560-1	ARM
	1			D3560-2	ARM
		1		D3560-3	ARM
			1	D3560-4	ARM
1	1	1	1	D3592-1	PLATE

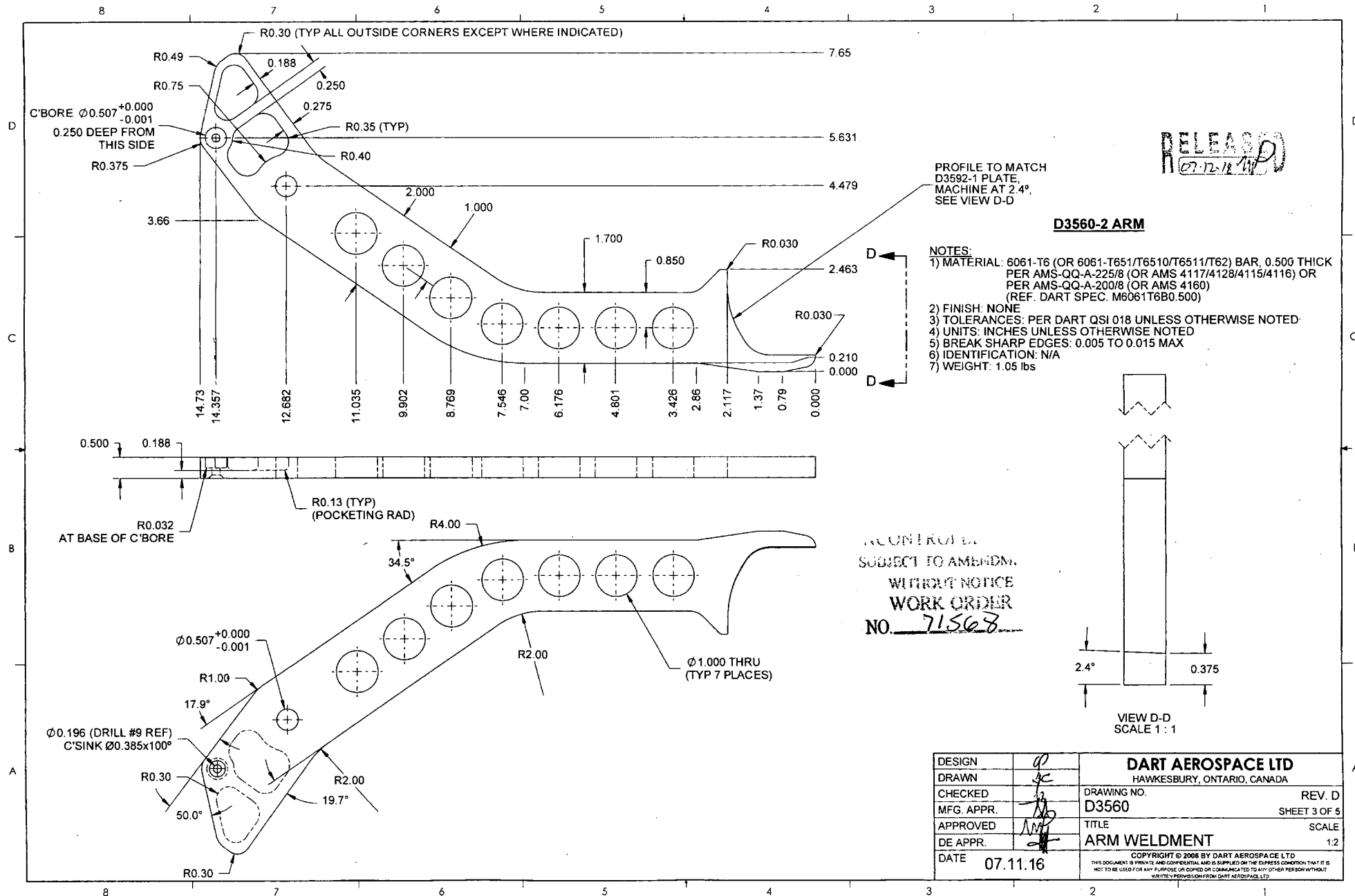
D	ADD D2808 PRESS FIT NOTE; REDRAWN IN SOLIDWORKS	DC	07.11.16
C	REMOVE POWDER COAT	CP	07.06.19
B	REDESIGN AS WELDMENT, ADD POCKETS	CP	07.01.15
A	NEW ISSUE	CP	06.08.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DRAWN	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	MFG. APPR.		
APPROVED	DE APPR.	DRAWING NO. D3560	REV. D
DATE	07.11.16	TITLE ARM WELDMENT	SHEET 1 OF 5
		SCALE	1:4

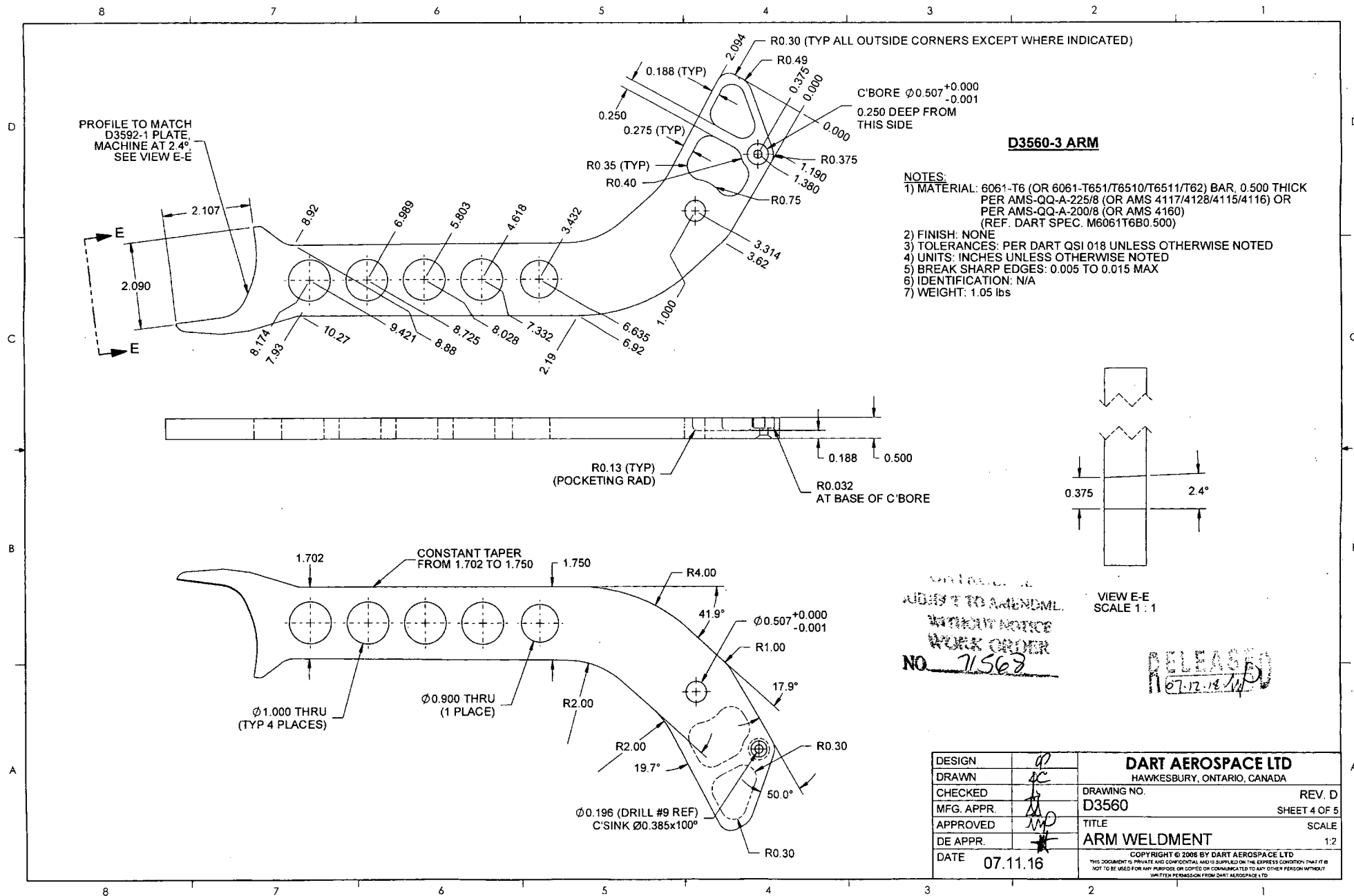
- NOTES:
1) MATERIAL: N/A
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 1.23 lbs (TYP)
8) WELDING: PER DART QSI 004

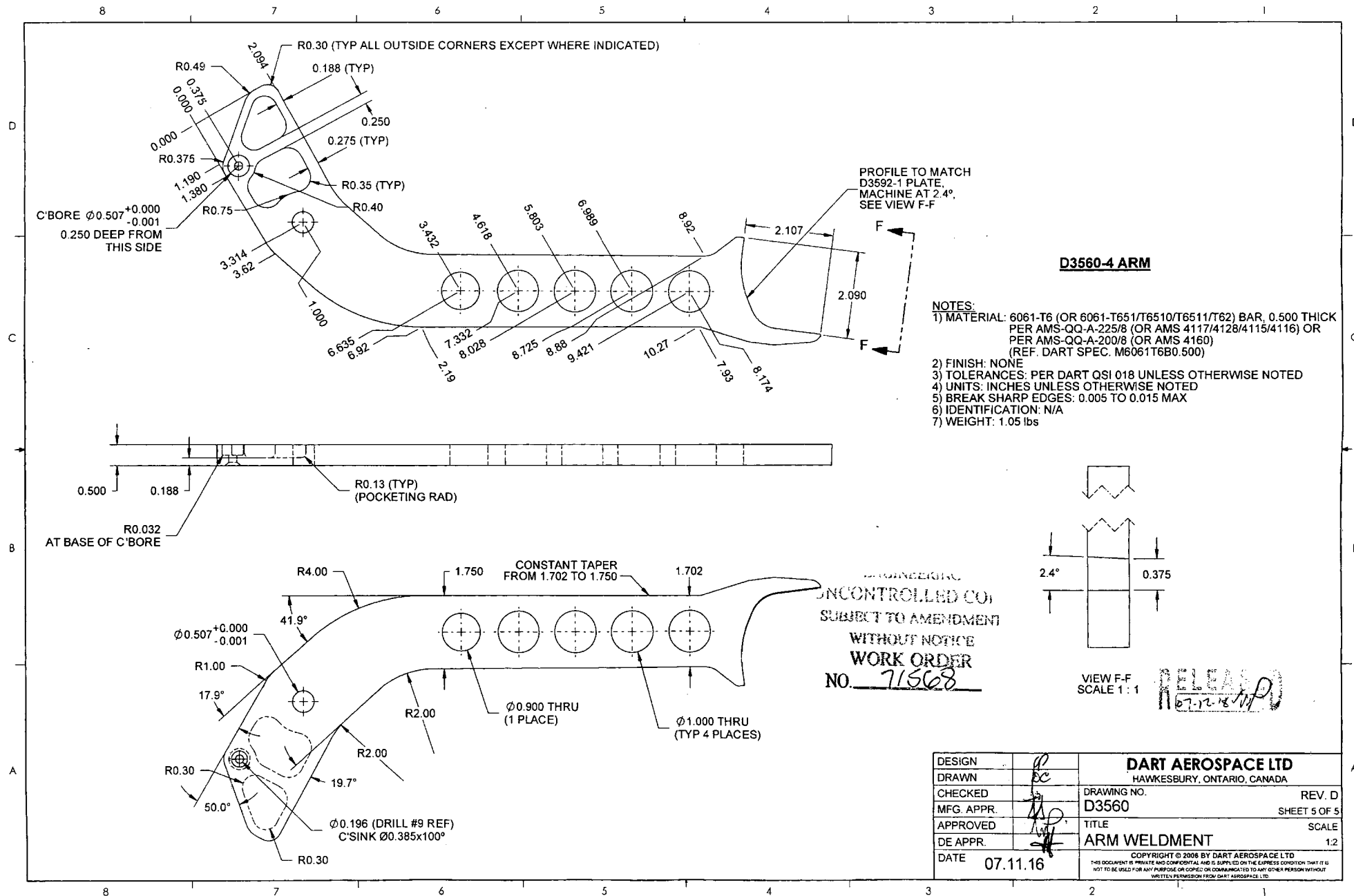
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DESIGN	JP	DART AEROSPACE LTD	
DRAWN	JC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3560	REV. D
MFG. APPR.		SHEET 2 OF 5	
APPROVED		TITLE ARM WELDMENT	SCALE 1:2
DE APPR.		COPYRIGHT © 2006 BY DART AEROSPACE LTD	
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DESIGN	PC	DART AEROSPACE LTD	
DRAWN	EC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3560	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		ARM WELDMENT	1:2
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